

Work Order ID 63331

Wednesday, October 27, 2010 3:50:48 PM



Page 1

Item ID: D4154-1

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 10/27/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: RP

Date: 10-10-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4154	A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

B10-10-29

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B10-10-29

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63331

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Page 2

Item ID: D4154-1

Accept

Revision ID:

Item Name: Plate

Start Date: 10/27/2010 Start Qty: 4.00

Required Date: 11/11/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

130

Form as per dwg

0.00

Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control



8/10/10/29

SB 10/11/01

8/10/11/01

(x4)

(4)

(x4)

Dart Aerospace Ltd

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Page 3

Item ID: D4154-1

Accept

Revision ID:

Item Name: Plate

Start Date: 10/27/2010 Start Qty: 4.00

Required Date: 11/11/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
StopSequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Packaging

Packaging

Identify as per dwg & Stock Location: *W/O*

0.00

Memo

0.00

*63330**EL 10-11-9- (X4)*

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*10/11/05**MF**10-11-5*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, October 27, 2010 3:50:53 PM

Page 1

Work Order ID: 63331



Parent Item: D4154-1



Parent Item Name: Plate

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA

Purchased

No

100

sf

91.5200

4.2697

17.97768



1810-10-29

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT20

91.52

111743

4.75

113062

38.77

115389

48

113065

④

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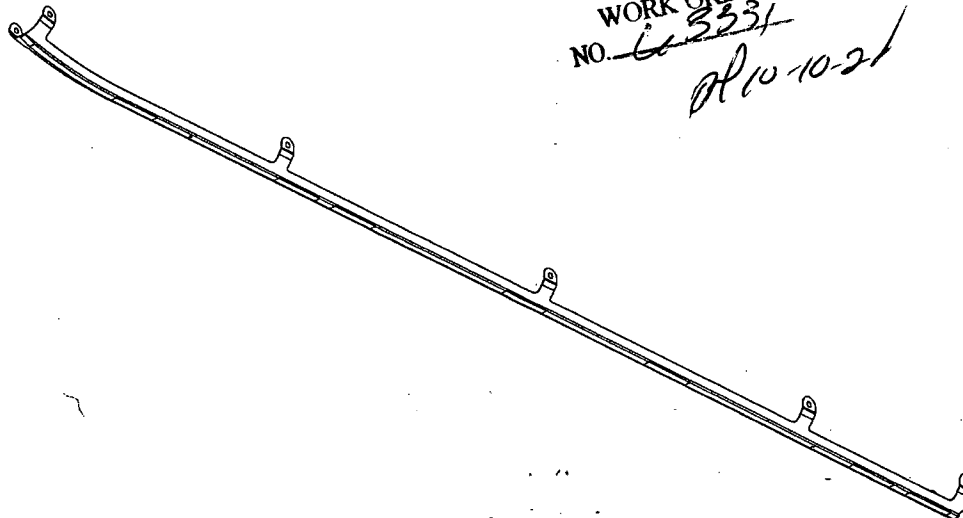
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *6-3331*
10-10-21



D4154-041 WEARPLATE ASSEMBLY

ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	PR 1422	SEALANT (SEE NOTE 11, SHT 2)

RELEASED
2010-09-15

A		NEW ISSUE		SC	10.07.22
REV.	DESCRIPTION			BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.			
DRAWN	SC	PORT HADLOCK, WA			
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A		
MFG. APPR.	<i>[Signature]</i>	D4154	SHEET 1 OF 3		
APPROVED	<i>[Signature]</i>	TITLE	SCALE		
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSEMBLY	NTS		
DATE		10.07.22		<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE RELEASED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

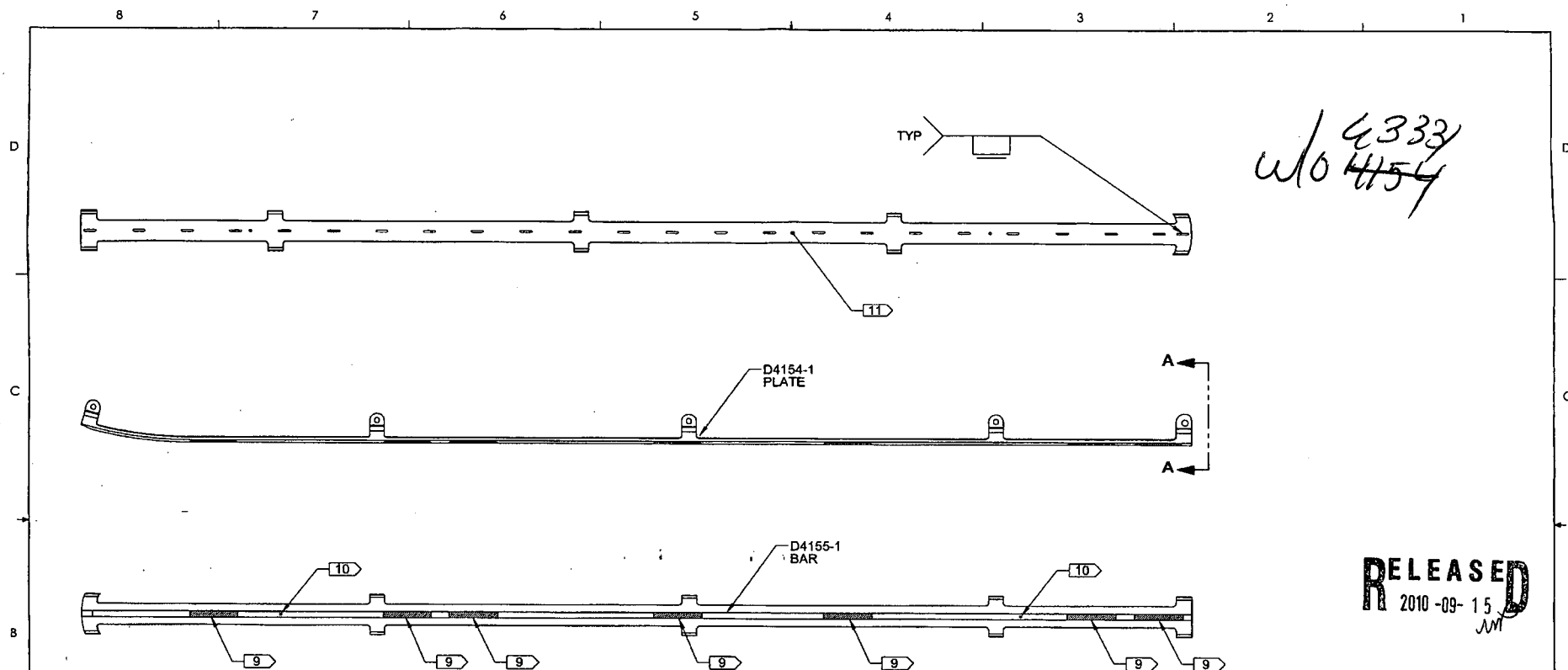
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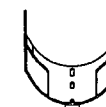
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D4154-041 WEARPLATE ASSEMBLY

RELEASED
2010-09-15
AM



SECTION A-A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 5.99 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) AFTER FINISH, COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR PROSEAL 1422 OR MIL-S-8802 CLASS B SEALANT, 0.020-0.040 THICK.

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	UP	DRAWING NO.	REV. A
MFG. APPR.	BE	D4154	SHEET 2 OF 3
APPROVED	AND	TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
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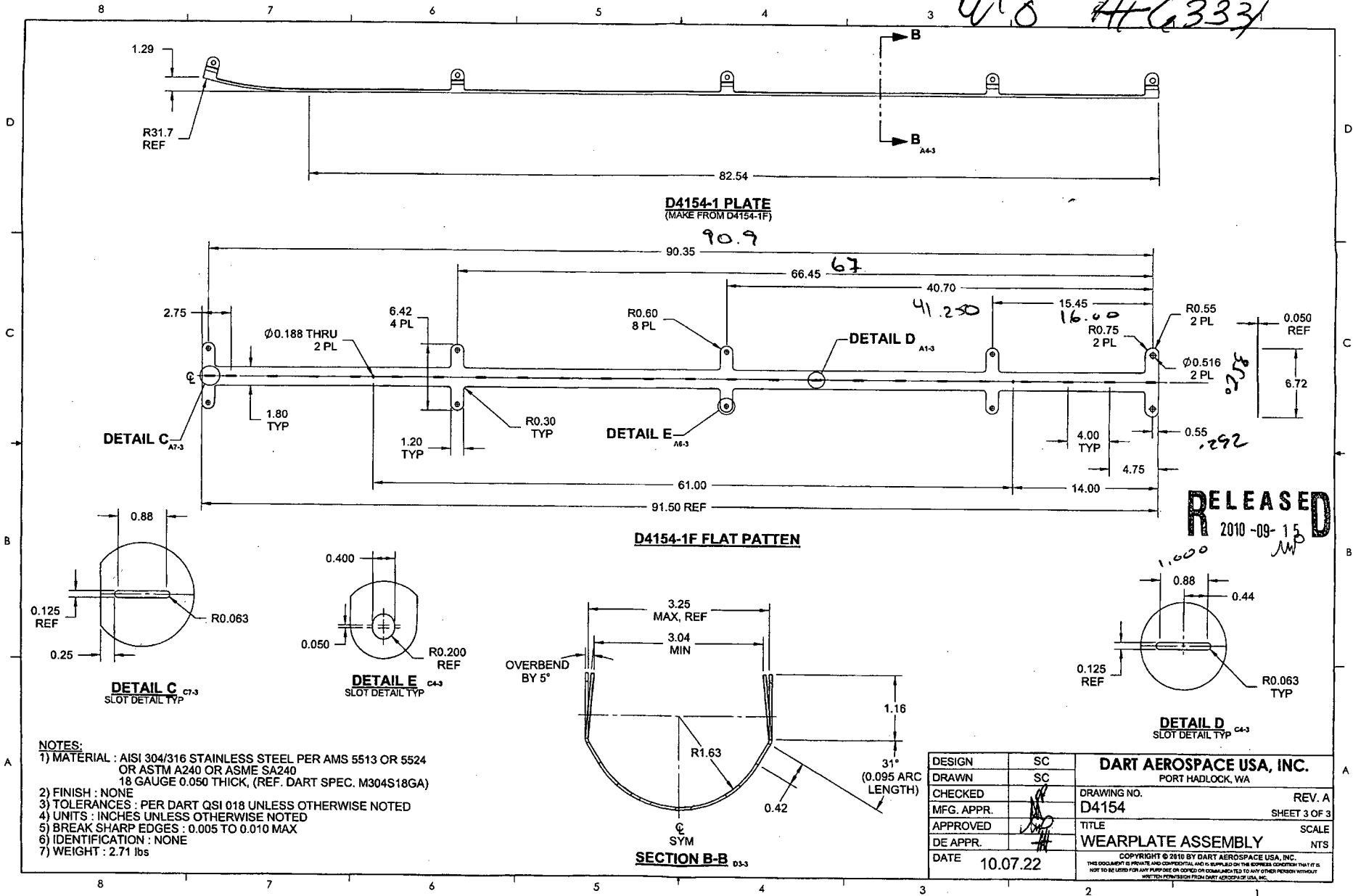
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W/O H-63331



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2010-09-15

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